

Work Order ID 57281

March 31, 2010 12:48:37 PM



Page 1

Item ID: D3826-041

Accept



Setup Start



Revision ID:

Item Name: Rib / Gusset Assembly

Stop



Start Date: 31/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 05/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *10-3-31*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3826

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together □ 2- locate D2325 on rib and weld as per dwg D3826 □ A/R ER316 S.S. Rod
Batch: *108160*

EL 10/04/07 *(62)*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10.04.07

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5.06.07

(46)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



Work Order ID 57281



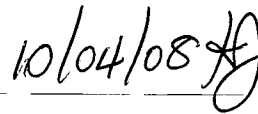
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Page 2

Item ID: D3826-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Rib / Gusset Assembly
Start Date: 31/03/2010 Start Qty: 6.00  Cust Item ID:
Required Date: 05/04/2010 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00	<u>SAP</u>	<u>10-04-07</u>		<u>6</u>			
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/04/08</u>  <u>MF</u> <u>10-4-7</u>

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 57281

Parent Item: D3826-041

Parent Item Name: Rib / Gusset Assembly


Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Date: 31/03/2010

Required Date: 05/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1  Basket Rib		Manufactured	No				Each	17.0000	6.0000			

EL 10-4-7

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA

17

50565

3

55979

4

56472

10

1

5

D3929-041

Manufactured No



Gusset Assembly

Each

5.0000

6.0000

EL 10-4-7

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA

5

56180

5

D3929-042

Manufactured No



Gusset Assembly

Each

13.0000

6.0000

EL 10-4-7

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA

13

50567

2

50869

9

56181

2

56705

6

W/O:		WORK ORDER CHANGES					
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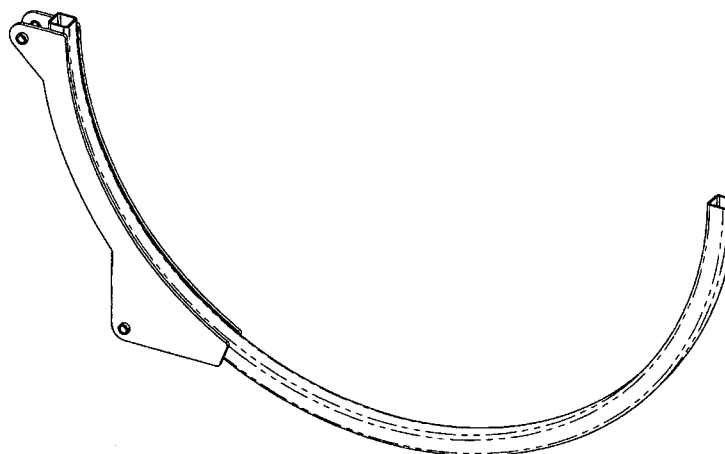
NOTE: Date & initial all entries

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57181

10-3-3



D3826-041 RIB/GUSSET ASSY

RELEASED
09/04/16

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 3.32 lbs

△

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3826	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

Dart Aerospace Ltd

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

 D3929-042
GUSSET ASSEMBLY

 D3929-041
GUSSET ASSEMBLY

TYP







0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

w/o 5781

RELEASED
9/24/16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3826	REV. B
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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